

Work Order ID 59928

Thursday, June 17, 2010 10:41:10 AM



Page 1

Item ID:	D3929-042		Accept		Setup	Start	
Revision ID:						Stop	
Item Name:	Gusset Assembly						
Start Date:	6/17/2010	Start Qty:	6.00		Cust Item ID:		
Required Date:	6/24/2010	Req'd Qty:	6.00		Customer:		
Reference:							

Approvals:	Process Plan:		Date:	10-6-17	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3929								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 10-6-17



AB 10-6-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D3929-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset Assembly

Start Date: 6/17/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/06/17

(X7)

140

Memo
Weld bushings D3907-1 as per dwg D3929

0.00



Large Fab

Large Fab

316L rod batch: M113328

0.00

SY 10/06/17 (7A)

150

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(D) PD 10.06.18

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Item ID: D3929-042

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 6/17/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/24/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solobels

x7

-042

170



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

Memo

0.00

SAD
10-06-18

7

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/21

MF
10-6-18

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Picklist Print

Thursday, June 17, 2010 10:41:13 AM

Page 1

Work Order ID: 59928

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 6/17/2010

Required Date: 6/24/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

146.8059

0.45

2.842105

3



304/316 0.125 Sheet



18-10-6-17

Location

Loc Qty

Loc Code

MAT

146.8059

114488

18.8059

114799

128

114488

12

D3907-1

Manufactured

No

130

Each

18.0000

2

12



Bushing



10/06/17

Location

Loc Qty

Loc Code

WA

18

57937

18

14

W/O:		WORK ORDER CHANGES					
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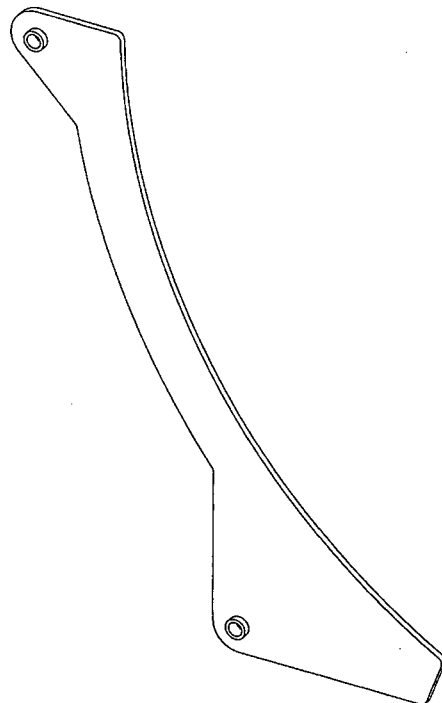
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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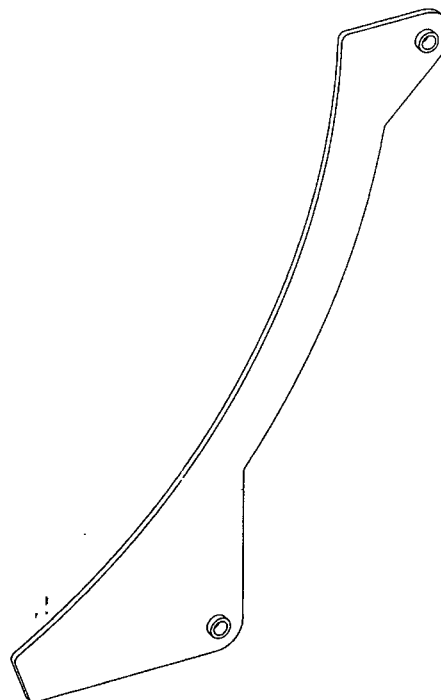
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59928

BS10-6-17

RELEASED
5/24/12

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A SHEET 1 OF 3
TITLE GUSSET ASSEMBLY	
SCALE NTS	
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8 7 6 5 4 3 2 1

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D3929-1
SUPPORT GUSSET
2 PL

0.25
2 PL, REF

D3907-1
BUSHING
2 PL

2 PL

D3929-1
SUPPORT GUSSET
REF

D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
2 PL

w/o 59928

2 PL

D3907-1
BUSHING
2 PL

0.25
2 PL, REF

D3929-1
SUPPORT GUSSET
REF

D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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